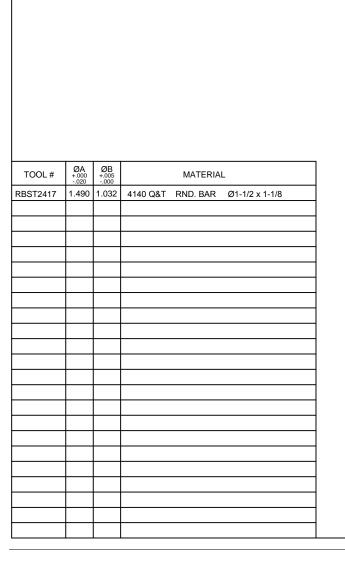


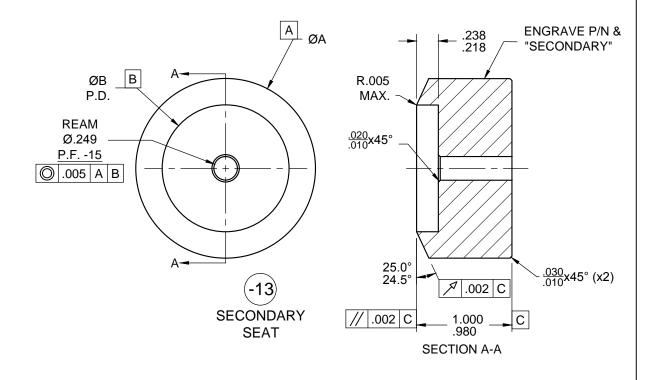
TOOL#	ØA +.000 002	PIN TYPE	QTY.	MATERIAL			
RBST2417	.372	III	2	1018	RND. BAR	Ø3/8 x 5/8	

NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

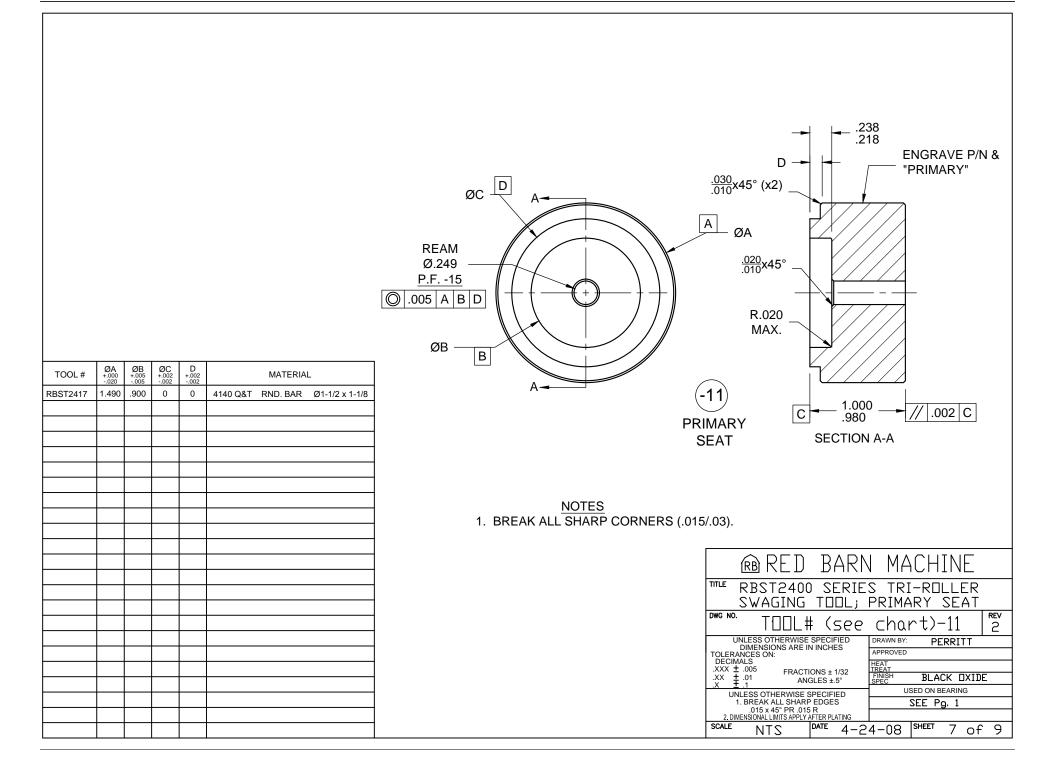
	® RED	BARN	1 MA	CHINE		
TITLE	RBST2400 SWAGING					
DWG NO		: (see			REV 2	
TOLER	JNLESS OTHERWISE DIMENSIONS ARE II ANCES ON:		DRAWN BY: APPROVED	PERRITT		
DECIN .XXX = .XX	FRACTI	ONS ± 1/32 GLES ±.5°	HEAT TREAT FINISH SPEC	BLACK DXI	DE	
UI	NLESS OTHERWISE S 1. BREAK ALL SHARF .015 x 45° PR .015	EDGES R	USED ON BEARING SEE Pg. 1			
2. DI SCALE	MENSIONAL LIMITS APPLY A		1 4-08	SHEET 9 C	t d	

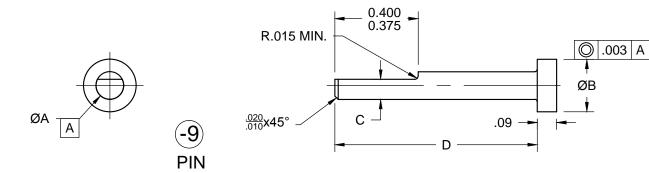




NOTES 1. BREAK ALL SHARP CORNERS (.015/.03).

RED BARN	N MACHINE		
RBST2400 SERIE SWAGING TOOL; S			
DWG NO. TOOL# (see	chart)-13 REV 2		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:	DRAWN BY: PERRITT APPROVED		
DECIMALS	HEAT TREAT FINISH SPEC BLACK DXIDE		
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES	USED ON BEARING		
.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SEE Pg. 1		
SCALE NTS DATE 4-2	4-08 SHEET 8 of 9		

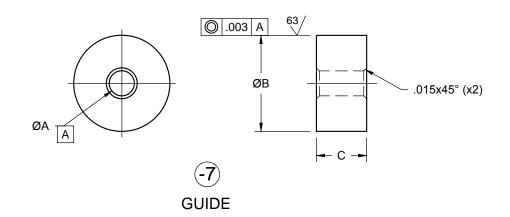




TOOL#	ØA +.000 001	ØB +.005 005	+.010 010	D +.020 020	MATERIAL
RBST2417	.248	.350	.190	1.100	MCMASTER-CARR PN: 93770A210

<u>NOTES</u>
1. BREAK ALL SHARP CORNERS (.015/.03).

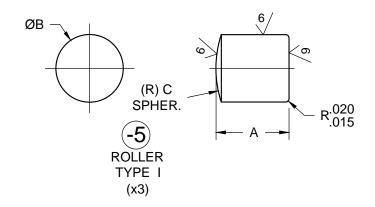
	® RED	BAR	N	МΔ	·CH	INE	
TITLE	RBST240 SW	O SERIE AGING				LLER	
DWG NO	· TOOL	# (see	· (cha	rt)-	-9	REV 2
TOLER	JNLESS OTHERWISE DIMENSIONS ARE ANCES ON:			RAWN BY:	PE	RRITT	
.XXX = .XX	± .005 FRACT	TIONS ± 1/32 IGLES ±.5°	FII	EAT NISH EC		K DXIDI	<u>-</u>
U	NLESS OTHERWISE 1. BREAK ALL SHAR	P EDGES			SEE Po		
	015. A 45° PR. MENSIONAL LIMITS APPLY	AFTER PLATING	\Box		LOUEET		
SCALE	2ТИ	DATE 4-	>4-	-08	SHEET	6 of	`9

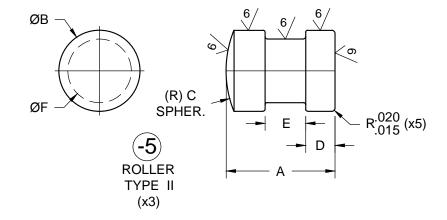


TOOL#	ØA +.001 001	ØB +.000 002	C +.000 010	MATERIA	AL
RBST2417	.253	.372	.344	BRONZE RND. BAR	Ø3/8 x 1/2

<u>NOTES</u>
1. BREAK ALL SHARP CORNERS (.015/.03).

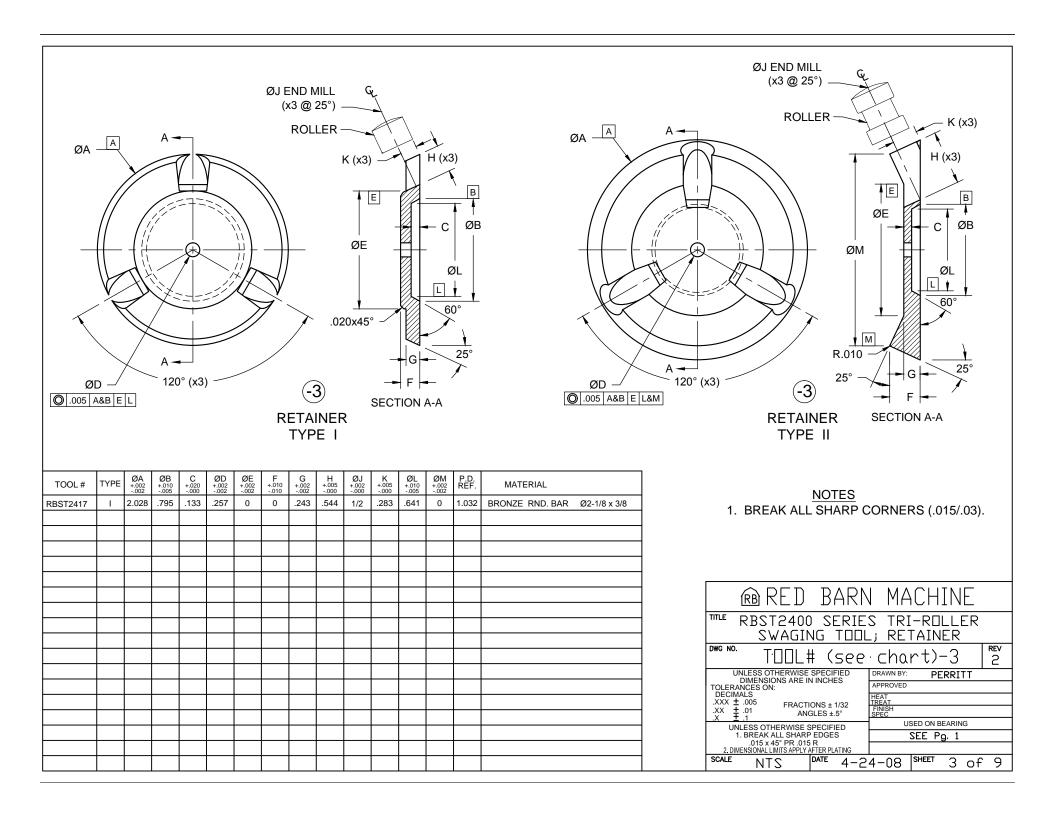
	® RED	BARI	N MA	ACH	INE	
TITLE	RBST2400 SWAC) SERIE JING TE				
DWG NO	· T:00L‡	# (see	· cho	rt)	-7	REV 2
TOLER	JNLESS OTHERWISE DIMENSIONS ARE II ANCES ON:		DRAWN BY		RRITT	
.XXX =	£ .005 FRACTI	ONS ± 1/32 GLES ±.5°	HEAT TREAT FINISH SPEC			
	NLESS OTHERWISE S		USED ON BEARING			
	1. BREAK ALL SHARF 015 x 45° PR .015. MENSIONAL LIMITS APPLY	R		SEE P	g. 1	
SCALE	2TN		4-08	SHEET	5 of	. 9

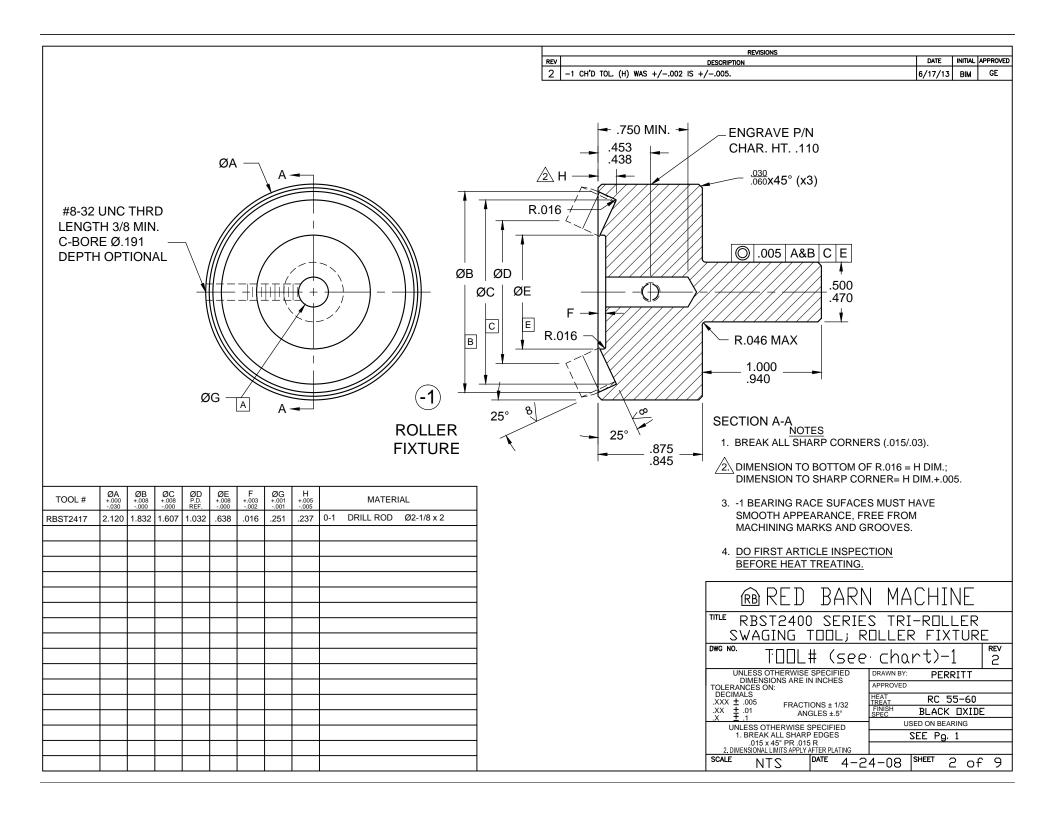




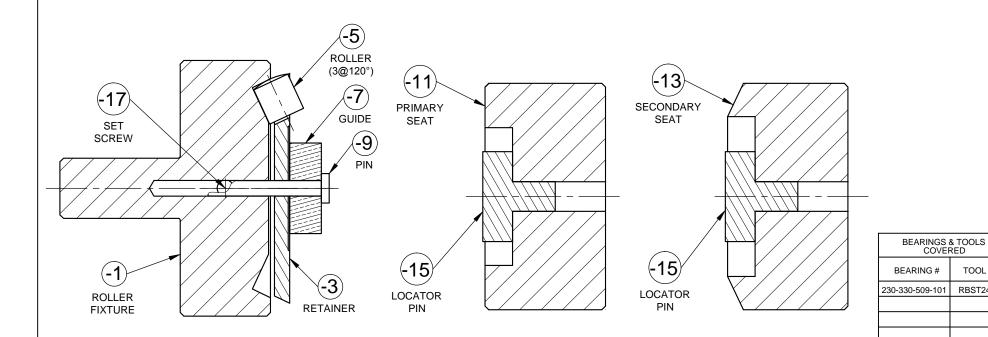
TOOL#	TYPE	A +.001 001	ØB +.001 001	(R) C +.002 002	D +.001 001	+.005 000	ØF +.000 005	MATERIAL		
RBST2417	I	.549	.497	.625	0	0	0	.497 MINUS	GAGE PIN	MSC#8904970?
·										
									<u>'</u>	·

	RB F	RED	В	ARN	1	МА	CH:	ΙN	E	
TITLE		T2400 ING T						LLI TY		`
		ו טוו.	⊔⊔∟	_ j	الا	LER	(6	<i>.</i> 1 1		<u> </u>
DWG NO	` Т	·OOL‡	‡ (see	. C	thai	rt)-	-5		REV 2
l	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES						PE	RRI	TT	
	ANCES OF					ROVED				
DECII .XXX		FRACTI	ONG T	1/22	HEA TRE	.T AT				
	± .01 F 1		GLES ±.		FINI	ISH C				
./ .		HERWISE S	PECIFI	FD	USED ON BEARING					
1. BREAK ALL SHARP EDGES					SEE Pg. 1					
2. DI		45° PR .015 LIMITS APPLY A		ATING						
SCALE	NΊ	-2	DATE	4-2	4-	·08	SHEET	4	of	9





	REVISIONS									
REV	DESCRIPTION	DATE	INITIAL	APPROVED						
1	CHANGED -5 ROLLER RADUIS FROM .005010, TO .015020; AND -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. ALSO CHANGED -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW						
1A	CH'D T/N'S FROM KST.	11/20/09	RJC							
2	-1 CH'D TOL. (H) WAS +/002 IS +/005.	6/17/13	ВІМ	GE						



NOTES

- 1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
- 2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
- 3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

ASSY QTY	B/O	PART#	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	0 or 1	SECONDARY SEAT	SEE CHART	8
		-15	1 or 2	LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

® RED BARN MACHINE

TOOL#

RBST2417

TITLE RBST2400 SERIES TRI-ROLLER SWAGING TOOLS

DWG NO. REV CHART ABOVE) 2 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DRAWN BY: PERRITT APPROVED TOLERANCES ON: DECIMALS LISTED PER ITEM .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 .X ± .1 LISTED PER ITEM ANGLES ±.5° USED ON BEARING UNLESS OTHERWISE SPECIFIED SEE ABOVE

1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING SCALE

DATE 4-24-08 SHEET 1 of 9 **STN**

		REVISIONS										
[REV	DESCRIPTION	DATE	INITIAL	APPR							
	_		-	-	-							

						1,			V)		® RED BARN MACHINE	
ASS QT	Y ASS Y QTY	Y B/C	PART#	UNIT		DESCRIPTION				MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.	TITLE ——	
			-1	1	RND			X		6061	Ø8-1/4 x 3-7/8	2	DWG NO	RE
						\mathcal{L}					UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS TOLERANCES ON: DECIMALS			
							\ '						DECIMALS .XXX ± .005 .XX ± .01 .X ± .01 .X + .00 OTHERWISE DECISION USED ON MODEL	
						<u> </u>							UNLESS OF HERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR.015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	_
Г	ASS	Y											$^{\text{SCALE}}$ NTS $^{\text{DATE}}$ 8–15–07 $^{\text{SHEET}}$ 1 c	f

REVISIONS									
REV	DESCRIPTION	DATE APPROVED							

NOT APPROVED FOR PRODUCTION

			PAR	Т#	QTY		DESCRIF	PTION		
			-1	ı	1					
		DRAWN BY: PERRITT			— \ Г		$D \wedge D M$	$\Lambda \Lambda \Lambda \cap$	LITN	
		CHECKED HEAT_		(<u>RB</u>	1 [2	くヒリ	RAKIN	MAL	$\Box\Box\Box$	
		TREAT FINISH SPEC		TITLE						
[USED ON MODEL	UNLESS OTHERWISE SPECIFIE DIMENSIONS ARE IN INCHES	D							
	?	TOLERANCES ON: DECIMALS .XXX ± .005 EDACTIONS + 1						-		
ł		XX ± .005 FRACTIONS ± 1 .XX ± .01 ANGLES ±.6			NO.		PART	#		REV.
f		UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES)				1 1 11 \ 1	11		
		.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	3	SCALE		NTS	DATE 1-28-0	06 ^{sheet} :	l of	1